

Work Order ID 53351-1

Blue



SPLIT-1

Page 1

*November 2, 2009 10:42:15 AM

Item ID: D3407-043

Accept

Setup Start

Revision ID: E

Stop

Item Name: Tow Ring

Start Date: 02/11/2009 Start Qty: ~~20.00~~ 16

Required Date: 13/11/2009 Req'd Qty: 20.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 09-11-2 Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3407

Rev E

100



Large Fab

Large Fab

Large Fab

Memo

Weld D3407-3/-5 using welding rod TIG174 as per Dwg D3407 & QSI 004 A/R TIG174 ROD Batch: 7101972

0.00

0.00

Cpl 09 11 09

110



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

Memo

0.00

0.00

09.11.10 25

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

2009-11-10



Work Order ID 53351

November 2, 2009 10:42:15 AM



Page 2

Item ID: D3407-043

Revision ID: E

Item Name: Tow Ring

Start Date: 02/11/2009 Start Qty: 20.00

Required Date: 13/11/2009 Req'd Qty: 20.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125 SprayPaint Spray Painting	Spray Painting per QSI005 4.2 Memo Prime B <u>110918</u> Spray Paintat Delfleet Blue B <u>113171</u> Clear Delfleet B <u>113088</u>	0.00 0.00				<u>ml</u>	<u>09</u>	<u>11</u>	<u>24</u>
135 QC Quality Control	QC14- Inspect Spray Paint Memo	0.00 0.00				<u>25</u>	<u>09-11-25</u>		<u>(10)</u>
150 Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00				<u>1/9/11/30</u>			<u>(14)</u>

Setup Start

Stop

Cust Item ID:

Customer:

Run Start

Stop

Duplicator/P3

Page 3

Work Order ID 53351

November 2, 2009 10:42:15 AM

Item ID: D3407-043
Revision ID: E
Item Name: Tow King
Start Date: 02/11/2009 Start Qty: 20.00
Required Date: 13/11/2009 Req'd Qty: 20.00
Reference:

Approvals: Process Plan: Date: Tooling: SPC (V/N): Date:
QC: Date: Stop Start Run Stop
Barcode Barcode Barcode Barcode Barcode Barcode

Sequence ID/ Work Center ID
Operation Description
Set Up/ Run Hours

QC21 - Final Inspection - Work Order Release
Memo
0.00
0.00

QC
Quality Control
09/11/17
09/11/30

09/11/30
14

Picklist Print

November 2, 2009 10:42:21 AM

Page 1

Work Order ID: 53351

Parent Item: D3407-043RevE

Parent Item Name: Tow Ring

Comments:



Start Date: 02/11/2009

Required Date: 13/11/2009

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3407-3RevE 		Manufactured	No			100	Each	0.0000	20.0000			
Stem D3407-5RevE 		Manufactured	No			100	Each	31.0000	20.0000			
Ring												

✓
B53350 → 20 Cpl 09/11

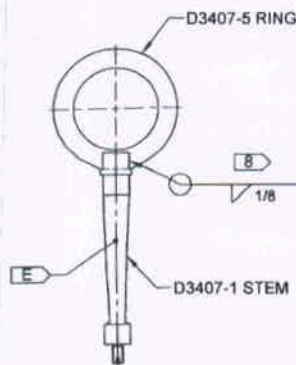
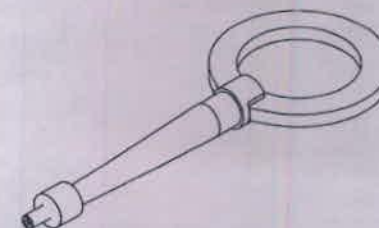
Cpl 09.11.09

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
WA	31	
51633	10	
52318	21	

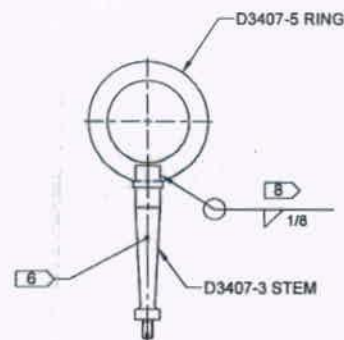
10 ✓
10 ✓

QTY -041	QTY -043	QTY -045	PART NUMBER	DESCRIPTION
X			D3407-041	TOW RING
	X		D3407-043	TOW RING
		X	D3407-045	TOW RING
1			D3407-1	STEM
	1		D3407-3	STEM
1	1	1	D3407-5	RING
		1	D3407-7	STEM

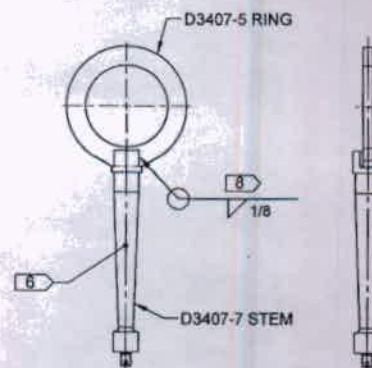
STANDARD
UNCONTROLLED
SUBJECT TO
WITHDRAWAL
WORK ORDER
NO. 53351
BT 09-11-2



D3407-041 TOW RING



D3407-043 TOW RING



D3407-045 TOW RING

RELEASED
07-08-01/18

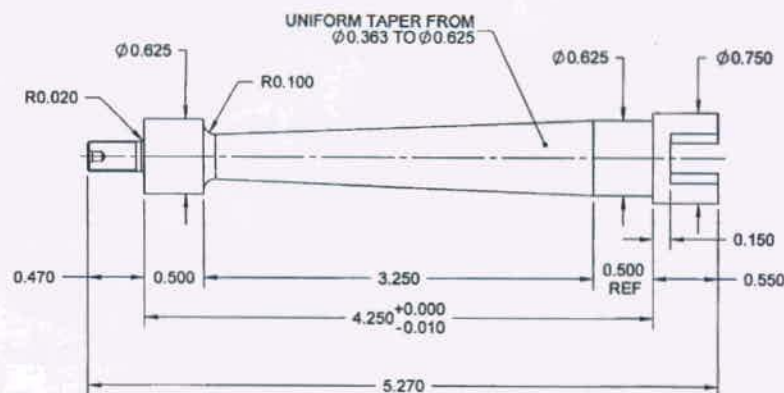
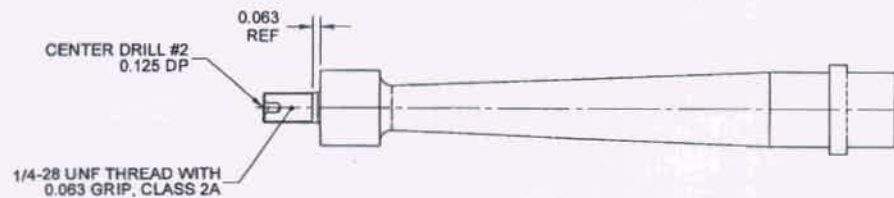
- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3407-XXX" USING BLACK FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D3407-041 - 0.60 lbs, D3407-043 - 0.53 lbs, D3407-045 - 0.61 lbs
 - 8) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING

E	ADD D3407-045 (ZN B2-1, D8-1); ADD D3407-7 (ZN B6-5); REVISED NOTE 8 TO ADD IDENTIFICATION (ZN A5-1); REASON: PRODUCTION FACILITY	PH	08.07.23
D	D3407-1/3 SLOT WAS ROUND NOW FLAT FOR ASSEMBLY WITH D3407-5 (ZN C2-2, C2-3); D3407-5 WAS ROUND NOW FLAT ON ONE END FOR ASSEMBLY WITH D3407-1/3 (ZN B8-4); REASON: PRODUCTION FACILITY	PH	08.04.07
C	-1/3 LONGER FOR FIT W/ WASHER	CP	05.09.09
B	UPDATE DIAMETER, THREAD CLASS ADDED	CP	05.06.17
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.23		

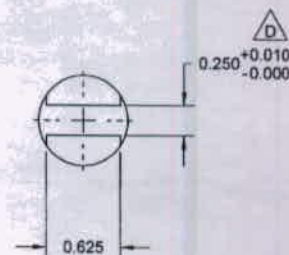
DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO.
D3407
REV. E
SHEET 1 OF 5
TITLE
TOW RING
SCALE
NTS

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D3407-1 STEM



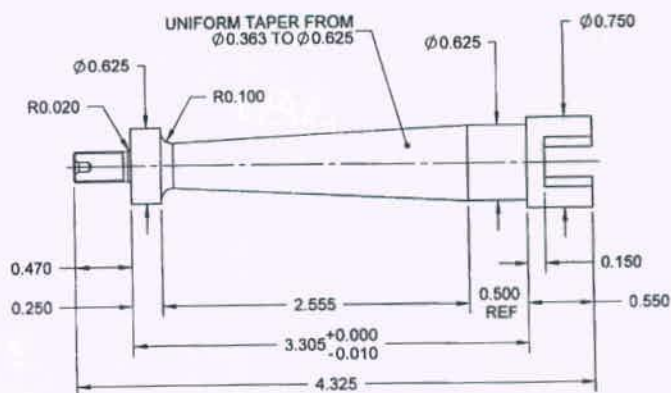
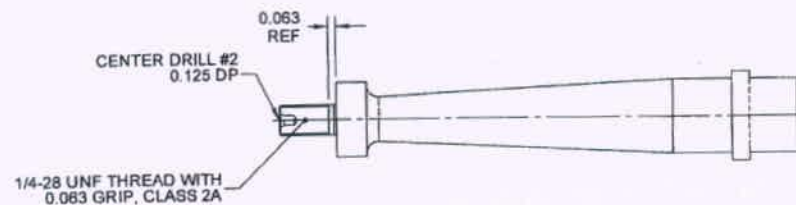
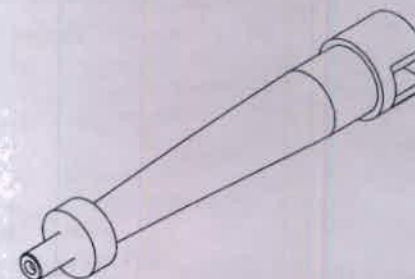
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WITHOUT NOTICE
WORK ORDER
NO. 03307

RELEASED
08-07-23

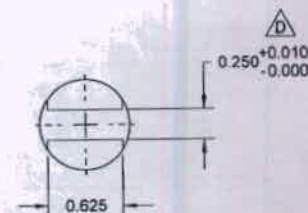
- NOTES:
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.33 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TOW RING	NTS
DATE	08.07.23	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC.	

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 WORK ORDER
 NO. 53351



D3407-3 STEM

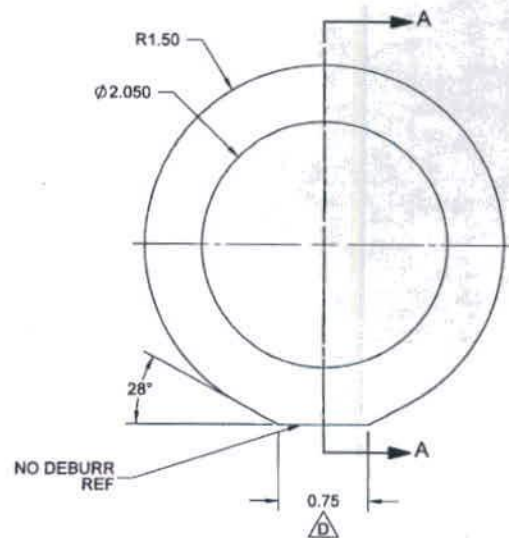


- NOTES:
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.27 lbs

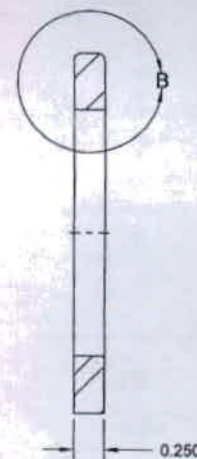
RELEASED
 04-08-01 R/P

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DRAWN	JP	PORT HADLOCK, WA	
CHECKED	JP	DRAWING NO.	REV.
MFG. APPR.	JP	D3407	SHEET 3 OF 5
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	TOW RING	NTS
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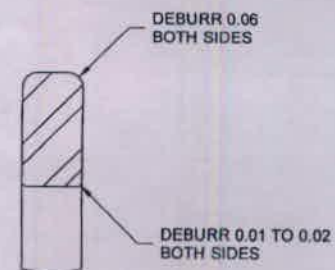
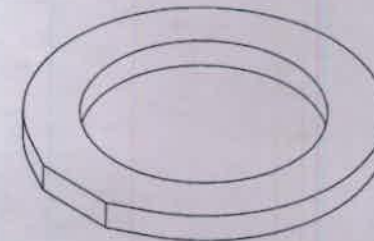
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WORK ORDER
NO. 53357



D3407-5 RING



SECTION A-A

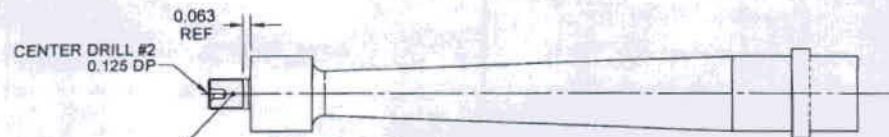


DETAIL B
SCALE 2X

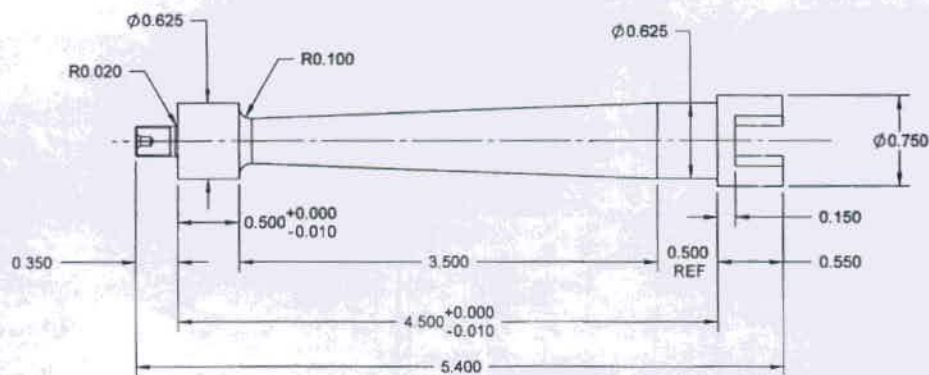
RELEASED
08-06-21-14

- NOTES:
- 1) MATERIAL: 17-4 PH SS BAR PER AMS 5604/5643 (REF. DART SPEC M17-4-B)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.27 lbs

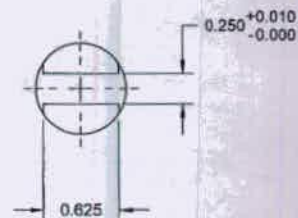
DESIGN	42	DART AEROSPACE USA, INC.	
DRAWN	1/1	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TOW RING	NTS
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1/4-28 UNF THREAD WITH
0.063 GRIP, CLASS 2A



D3407-7 STEM



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WITHOUT NOTICE
WORK ORDER
NO. 5330

RELEASED

- NOTES:
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.34 lbs

DESIGN	AJS	DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV.
MFG. APPR.		D3407	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TOW RING	NT
DATE	08.07.23	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC.	
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Work Order ID 53354-1

November 2, 2009 10:43:05 AM

Blue ASAP

SPLIT-1



Page 1

Item ID: D3414-041

Revision ID: C

Item Name: Lug Assembly

Start Date: 02/11/2009 Start Qty: ~~20.00~~ 12

Required Date: 13/11/2009 Req'd Qty: 20.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: 09-11-2

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3414

Rev C

100



Waterjet

FLOW CNC Waterjet

0.00

Memo

0.00

1-Cut as per Dwg D3414-1

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

IB 9-11-2

20

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

IB 9-11-2

Work Order ID 53354

November 2, 2009 10:43:05 AM



Page 2

Item ID: D3414-041

Revision ID: C

Item Name: Lug Assembly

Start Date: 02/11/2009 Start Qty: 20.00

Required Date: 13/11/2009 Req'd Qty: 20.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

2) Serial 02

Accept Qty
(25)

Reject Qty
took one

Per E
Tuglin

(PTG)

130



Brake NC

Brake NC

Memo

1-Deburr

2-Form using DT8254 as per Dwg D3414

0.00

0.00

809/11/03

(25)

8

140



Large Fab

Large Fab

Memo

1- Weld using location Jig DT8484 as per Dwg D3414
A/R S.S. welding rod Batch: M102421

0.00

0.00

EL 9-11-7

(X25)

W/O: 53354		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
9/11/2	# 120	Took Qty 1 Part for QC inspection template	S	9/11/2	(8)	[Signature] 05.11.10	[Signature] 02/11/2

Part No: D 3414-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53354

November 2, 2009 10:43:05 AM



Page 3

Item ID: D3414-041

Accept

Revision ID: C

Item Name: Lug Assembly

Start Date: 02/11/2009 Start Qty: 20.00

Required Date: 13/11/2009 Req'd Qty: 20.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

091109 (25)

160

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

25 05-11-10

165

Spray Painting per QSI005 4.2

0.00

SprayPaint

Memo

0.00

Spray Painting

Prime B 110918
Spray Paintat Delfleet Blue B 113171
Clear Delfleet B 113028

ml 09 11 24

Work Order ID 53354

November 2, 2009 10:43:05 AM



Page 4

Item ID: D3414-041
 Revision ID: C
 Item Name: Lug Assembly
 Start Date: 02/11/2009 Start Qty: 20.00
 Required Date: 13/11/2009 Req'd Qty: 20.00
 Reference:

Accept



Setup Start



Stop



Cust Item ID:
 Customer:



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
 Work Center ID

175



QC

Quality Control

Operation
 Description

QC14- Inspect Spray Paint

Set Up/
 Run Hours

0.00

Memo

0.00

Draw
 Number

Draw
 Rev.

Plan
 Code

Accept
 Qty

Reject
 Qty

Reject
 Number

Insp.
 Stamp

IT 09-11-25 (17)

190



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

0.00

09/11/30 (17)

200



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/11/30 (17)

09/11-30

(17)

Picklist Print

November 2, 2009 10:43:09 AM

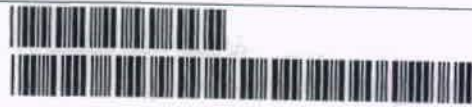
Page 1

Work Order ID: 53354

Parent Item: D3414-041RevC

Parent Item Name: Lug Assembly

Comments:



Start Date: 02/11/2009

Required Date: 13/11/2009

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

M304S12GA

304/316 0.100" Sheet



Purchased

No

100

sf

65.5900

30.4000



IB 9-11-2

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

65.59

112290

1.59

112611

64

112290

⓪

Manufactured

No

140

Each

42.0000

20.0000



EL 9-11-5

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

42

50469

2

52599

20

52652

20

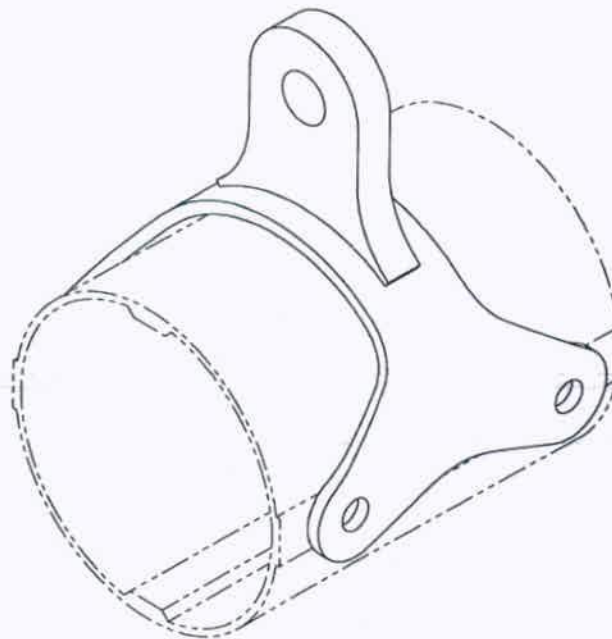
2
20
3

D3414-3RevB



Lug

ITEM No.	QTY.	PART NUMBER	DESCRIPTION
1	X	D3414-041	LUG ASSEMBLY
2	1	D3414-1	LUG BRACKET
3	1	D3414-3	LUG



D3414-041 LUG ASSEMBLY

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WORK ORDER

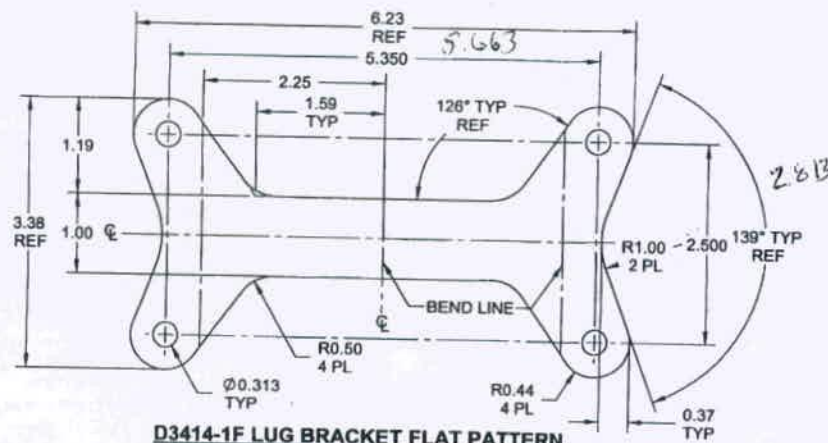
NO. 53354

B-109-11-2

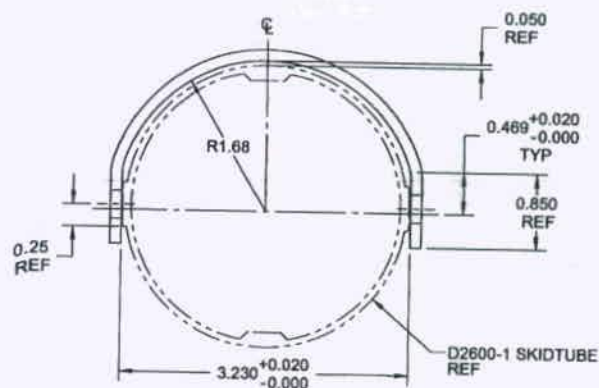
RELEASED
01/16/15

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.52 lbs

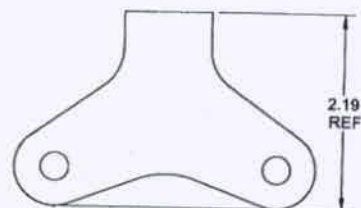
C	BREAK SHARP EDGES FOR -3 NOW 0.030-0.060 WAS 0.010-0.030 (ZN A7-3)	CP	09.06.17
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERN FOR -1 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). FLAT SPOTS REMOVED FROM -1 (PART NOW "U" SHAPED) FOR EASE OF MANUFACTURE. B7-3 ADDED TOLERANCE TO 3.230 DIM. C2-3. 1.12 DIM WAS 1.20.	AJS	08.09.23
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	CP		
DRAWN	CP		
CHECKED	CP		
MFG. APPR.	CP		
APPROVED	CP		
DE APPR.	CP		
DATE	09.06.17		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3414 TITLE LUG ASSEMBLY REV. C SHEET 1 OF 3 SCALE NTS COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



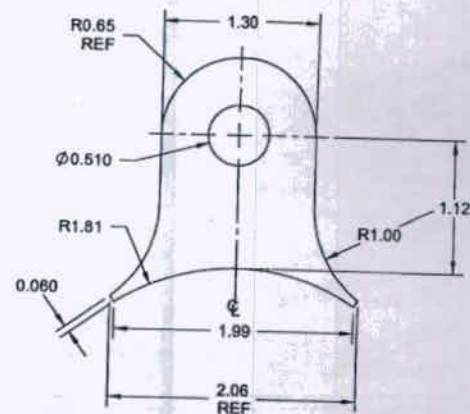
D3414-1F LUG BRACKET FLAT PATTERN



D3414-1 LUG BRACKET



SIDE VIEW FOR REF ONLY



D3414-3 LUG



NOTES:
1) MATERIAL: -1: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S12GA

-3: AISI 304/316 STAINLESS STEEL PLATE
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S

2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: -1: 0.010 TO 0.020 MAX
-3: 0.030 TO 0.060 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: N/A

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29/10/2006

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DRAWN	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CP	DRAWING NO.	REV. C
MFG. APPR.	CP	D3414	SHEET 3 OF 3
APPROVED	CP	TITLE	SCALE
DE APPR.	CP	LUG ASSEMBLY	NTS
DATE	09.06.17	COPYRIGHT © 2008 BY DART AEROSPACE LTD	

